

Comment: PACKAGING RESOURCE #1
Identify and Stock

Comment: INSPECT WORK TO CURRENT STEP

Location:

U

Str 09-06

PACKAGING RESOURCE #1



14

Da	art	Ae	ros	pace	Ltd
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W/O:			WORK ORDER CHANGES								
DATE	STEP	PROCEDU	RE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	):	PAR #: Fa	ault Category:	NCR: Ye	s No DQ	A: 🔼	Date: _(	12/09/06			

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

ication Approva	Approva QC Inspecto

NOTE: Date & initial all entries

Date:

Monday, 7/30/2007 1:52:25 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 33780

Part Number: D2659UP

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

QC21



FINAL INSPECTION/WO RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart .	Aeros	pace	Ltd
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W/O:			WORK ORDER	CHANGES				
DATE	STEP	PROCEDU	RE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #· Fa	ult Category:	NCP: Ves	No DO	۸.	Date:	

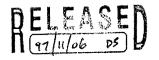
QA: N/C Closed: \_\_\_\_ Date: \_

NCR:		WOF	RK (	OR	DER NON-CONFORMANCE (N	VCR)			
		Description of NC			Corrective Action Section B		Verification	Ammanal	Ammerial
DATE	STEP	Section A	<b>Initia</b> Chief E		Action Description Si Chief Eng E	ign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: D	ate & initia	al all entries	$\neg \uparrow$			1			· · · · · · · · · · · · · · · · · · ·

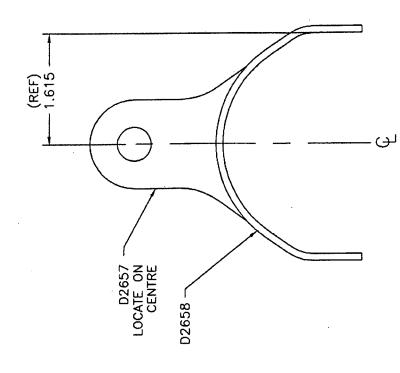
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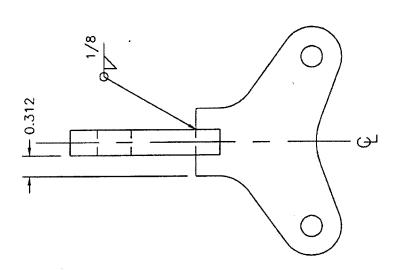


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DESIGN	DRAWN BY	DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT,	
CHECKED	APPROVED	DRAWING NO.	REV. A
4	(U	D2659	SHEET 1 OF.1
DATE		TITLE	SCALE
97.11.03		LUG ASSEMBLY	NTS
A	97.11.03	NEW ISSUE	



OTHERWISE NOTED





D2659 LUG ASSEMBLY

WELD PER DART QSI 004 FINISH: POWDER COAT PER DART QSI 005 4.4 TOLERANCES ARE PER DART QSI 018 UNLESS 0 PART IS SYMMETRIC ABOUT CENTRE—LINES (\$\mathbb{C}\$) SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

Description   Comment				•	Dart A	erospace	Ltd.	
Job Number : 33769   Estimate Number : 10339   P.O. Number : 10339			Proces	s Sheet	<b>2</b>			
## Part Number   1026988   1026988   1026988   1026988   1026988   1026988   1026988   1026988   10269	Job Number	: 33780B		Drawing Name	: LUG BRACKET			
Prist   Seve	P.O. Number	· ILLA						į
Previous Run   32376B		: NC	1	Project Number	: N/A			
Due Date		: <b>/\forall \sqrt{\sq}}}}}}}}}} \end{\sqrt{\sq}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}}</b>			4 .			
Seq. #:   Machine Or Operation:   Description:		:		Due Date		Qty:	12 Um:	Each
Est Rev B Now on Waterjet 06-08-23 JLM  Additional Product  Seq. #: Machine Or Operation: Description:  1.0 M1010S120A 1010H025M216aA SHEET  1.0 GAUGE 100 THK Batch: M 1010 944 RD7-08-05  2.0 WATER JET  1-Cut as per Dwg D2858 Dwg Rev. D Prog Rev. D Prog Rev. D 2-Deburr if necessary SAP BJ08/09  3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE  4.0 CCB SECOND CHECK  Comment: INSPECT PARTS AS THEY COME OFF MACHINE  4.0 CCB SECOND CHECK  Comment: SECOND CHECK  Comment: SECOND CHECK  D BRAKE SECOND CHECK  Comment: NC BRAKE								
Seq. #:   Machine Or Operation:   Description:	Comment							
Seq. #:   Machine Or Operation:   Description:	Additional Produc	ot	· · · · · · · · · · · · · · · · · · ·					
Seq. #:   Machine Or Operation:   Description:								
1.0   M10105129A   10101025/A21/8aA SHEET   1010/1025/A21/8aA SHEET   12 GAUGE .100" THK   Batch: M 1010/44   Bo7-08-05	Job Number:							
Comment: Qty:: 0.1197 sf(s)/Unit Total: 1.4364 sf(s) 1010/1026/A21/6aA SHEET 12 CAUGE: 100" THK Batch: M Iol O44	Seq. #:	Machine Or Operation:				<u> </u>		
10/10/1025/A21/6aA SHEET 12 GAUGE 100* THK Batch: M 101 O94	1.0	M1010S12GA 	1010/1025/A:	21/6aA SHEET				
10/10/1025/A21/6aA SHEET 12 GAUGE 100* THK Batch: M 101 O94								
12 GAUGE .100* THK Batch: M IOL 944  RBOT - 08 - 05  20 WATER JET  1-Cut as per Dwg D2858 Dwg Rev: D Prog Rev: D 2-Deburr if necessary  30 QC2  INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE  40 QC8  Comment: SECOND CHECK  DRAKE  Comment: NC BRAKE  Comment: NC BRAKE	Comn		1.4364 sf(s)					
Batch: M 101 094					-			
Comment: FLOW WATER JET  1-Cut as per Dwg D2858 Dwg Rev: D  2-Deburr if necessary  3.0 QC2  INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE  Comment: SECOND CHECK  SECOND CHECK  Comment: NC BRAKE  Comment: NC BRAKE		,					·	
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1 Som to Control of the Control of t	Comm	pent: NC PDAVE	·					
	Contra		A 108100	1 (6)				

Page 1

2-Bend on CNC brake using DT8254Identify as D2658

Form: mrocess

## **Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES								
DATE	STEP	PROCEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								<b>-</b>			
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Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_\_ NCR: Yes No DQA: Date: OHONO

QA: N/C Closed:

Date:

NCR:		W	ORK	ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A		ial Eng	Corrective Action Section B  Action Description Chief Eng	Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector	
07/02/15	D 2.0	one portiseron holes are old. R.C. Port money dumi	18	2	Sorgo and destroy No Replace	SB 09/07/15	Co orbolis	Ban	orlæks	
		water jetting								
		ч.					•			

NOTE: Date & initial all entries

Monday, 7/30/2007 1:52:28 PM Date: Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: LUG BRACKET Part Number: D2658 Job Number: 33780B Job Number: Description: Machine Or Operation: Seq. #: INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE U 87:09.06 Job Completiòn

Dart Aerospace L	Ltd	ce	ac	D	S	ď	er	Α	rt	a	D
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Dart Ae	rospace	Lta										
W/O:			WORK ORDER CHANGES									
DATE	STEP	PROCEDU	RE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								:				
Part No	:	PAR #: Fa	ult Category:		NCR: Yes	No DQ	A:	Date:				
					QA: N	I/C Close	d:	_ Date: _	·			
NCR:		WORI	ORDER NON-COI	NFORMAN	CE (NCF	₹)						
		Description of NC	Corrective Action	on Section B	3	Vorifi	ration	Approval	Approval			

NCR:		,	WORK	ORDER NON-CONFORMANCE (NCR)						
					Corrective Action Section B	Varification		A		
DATE	STEP		tial FEng			Verification Section C	Approval Chief Eng	Approval QC Inspector		
						·				
			ı							

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33780B
Description: Lug Bracket	Part Number:	D2658
Inspection Dwg: D2658 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST							
	X	First Arti	cle	_ Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
1.00	+/-0.030	1.∞	*				
2.500	+/-0.010	2500	*				
5.205	+/-0.010	5,705	* *				
Ø0.313	+0.006/-0.001	314	*				
0.100	+/-0.010	,loc	¥				
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easured by:	in	Audited by:			Prototype App	roval	N/A

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 67-08-65	Date: 07/00/0下	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.11.13	New Issue	KJ/JLM	\(\( \lambda \) \( \lambda \)
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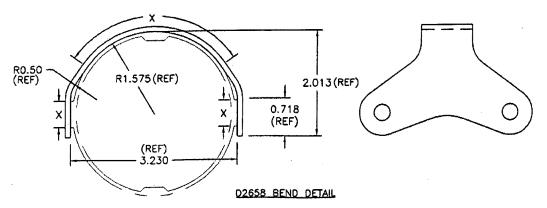


DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHEC	KED	APPROYED	DRAWING NO. REV. D			
	A -	1 KE	D2658 SHEET 1 OF 1			
DATE			TITLE SCALE			
98.	12.14		LUG BRACKET 5:9			
Α		97.11.03	NEW ISSUE			
В		97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE			
С		98.10.23	UPDATE MATERIAL (TSR A1114)			
D		98.12.14	REMOVE TOOLING HOLE (TSR A1040)			

RELEASED 98.12.14 DS

(TYP) 0.37	BEND AXIS	Ø0.313 (TYP)
	1	1.00 2.500 (TYP)
	1.27 (TYP) 5.205	R0.44 (TYP)

D2658 FLAT PATTERN SYMMETRICAL ABOUT BOTH CENTRE-LINES (  $\mathcal{G}$  )



D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY RETURN TO ENGINEERING

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 CAUGE) NTROLLED COPY

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

WITHOUT NOTICE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

WORK ORDER NO. 33780B